

Work Order ID 62720

Wednesday, October 06, 2010 3:56:39 PM



Page 1

Item ID: D3637-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 10/6/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-10-07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3637	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3637 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

304 .080

B 10-10-19

(12)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-10-19

120

0.00



QC8- Inspect parts - second check

QC

Memo JH-03

0.00

Quality Control

1210-10-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Accept

Revision ID:

Item Name: Bracket Assembly

Start Date: 10/6/2010 Start Qty: 8.00

Required Date: 10/15/2010 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3637

SB 10/10/25

(12)

140

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- drill holes as per dwg using DT8979 □ 2-C'Sink as per Dwg D3637 □ 3-
Install Nut plate as per Dwg D3637

EP 10/10/26 (12)

150

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

SB 10/10/26

(42)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 62720

Wednesday, October 06, 2010 3:56:39 PM

Page 3

Item ID: D3637-041

Accept

Revision ID:

Item Name: Bracket Assembly

Start Date: 10/6/2010 Start Qty: 8.00

Required Date: 10/15/2010 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 244A

0.00



Packaging

Memo

0.00

Packaging

10/10/26 SFC 122

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/27 MF 10-10-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 06, 2010 3:56:43 PM

Page 1

Work Order ID: 62720

Parent Item: D3637-041

Parent Item Name: Bracket Assembly




Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20426AD3-3  Rivet		Purchased	No			100	Each	4,419.000	2	16			
<div> <div>Location</div> <div>ST316</div> <div>19099</div> <div>7681</div> </div> <div> <div>Loc Qty</div> <div>4419</div> <div>4407</div> <div>12</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
M304S14GA  304SS sheet .080		Purchased	No			140	sf	105.3108	0.09	0.757895			
<div> <div>Location</div> <div>MAT20</div> <div>113295</div> </div> <div> <div>Loc Qty</div> <div>105.3108</div> <div>105.3108</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
MS21059L4  Nutplate		Purchased	No			140	Each	40.0000	1	8			
<div> <div>Location</div> <div>ST301</div> <div>114718</div> <div>ST302</div> <div>112243</div> </div> <div> <div>Loc Qty</div> <div>30</div> <div>30</div> <div>10</div> <div>10</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													

Handwritten: 9/5/10/10/26
34

Handwritten: D,
HB 10-10-19

Handwritten: 12

Handwritten: 113595
9/5/10/10/26

Handwritten: 2
10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

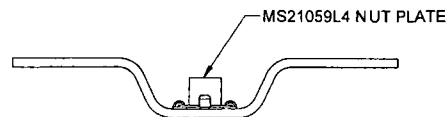
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

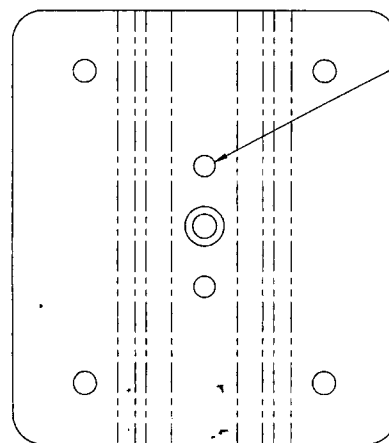
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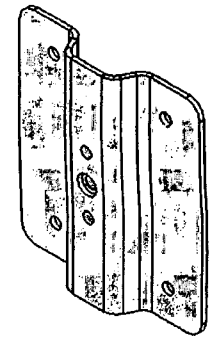


MS21059L4 NUT PLATE



MS20426AD3-3 RIVET
(2 PLACES)

D3637-1 BRACKET



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 62720
BS10-10-07

D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

D3637-041 PARTS:

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

RELEASED
76-02-05

B	FOR D3637-1, 1 15 WAS 1 30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE; REPLACES G10608, G10602 & G10609	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE		
CHECKED	AF	DRAWING NO.	REV. B
MFG. APPR.	EP	D3637	SHEET 1 OF 3
APPROVED	AF	TITLE	SCALE
DE APPR.	AF	BRACKET	1:1
DATE	07.12.18	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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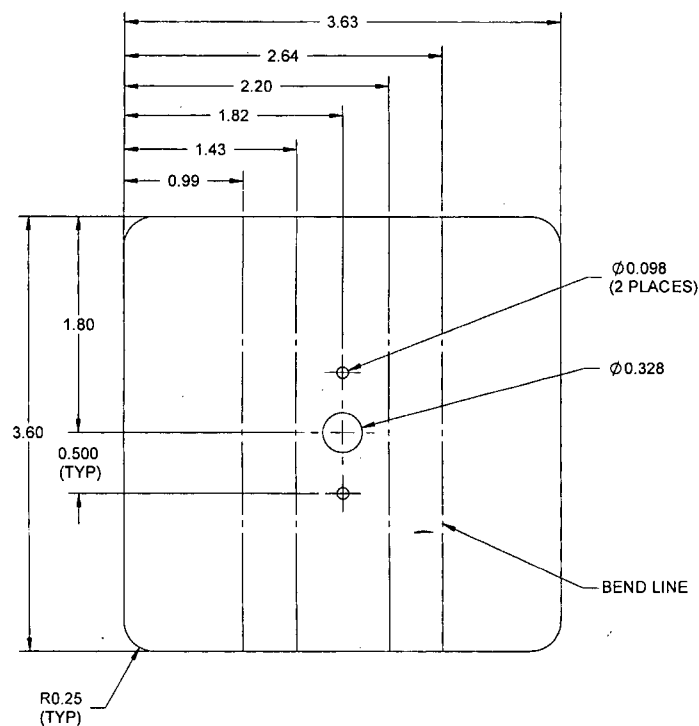
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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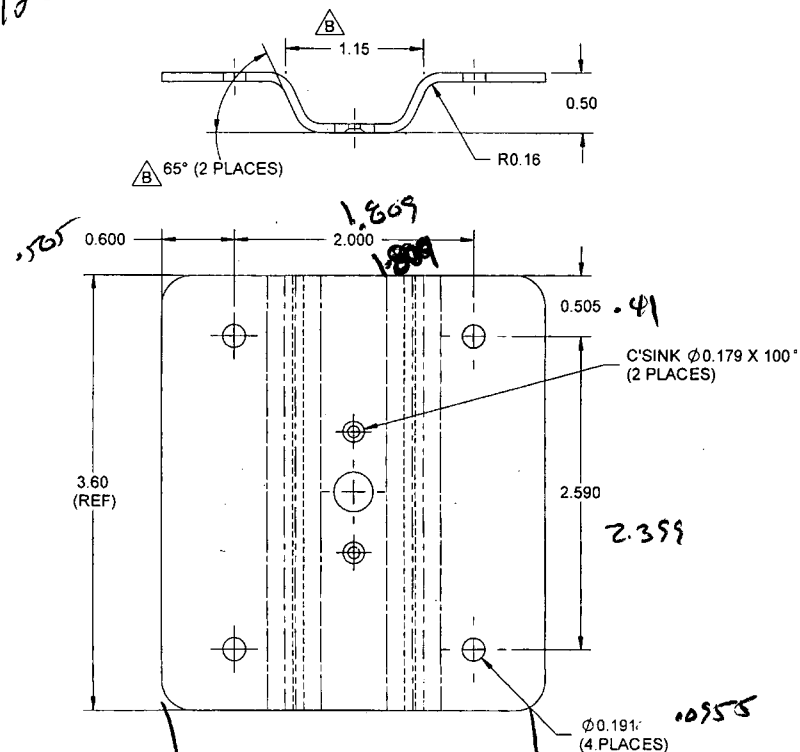


D3637-1F FLAT PATTERN

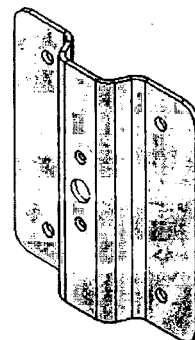
D3637-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

wlb 42728



D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)



DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AL	DRAWING NO.	REV. B
MFG. APPR.	LO	D3637	SHEET 2 OF 3
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DE APPR.	JS	BRACKET	1:1
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08-20-07

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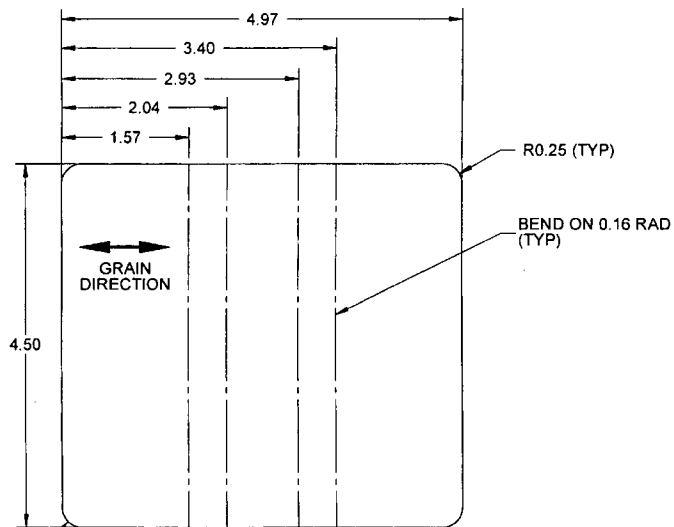
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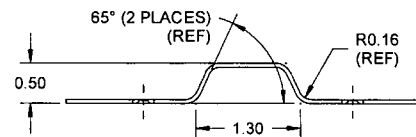
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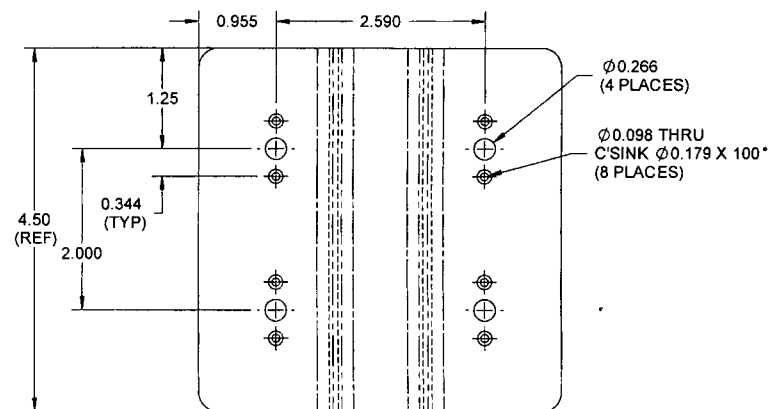
NOTE: Date & initial all entries



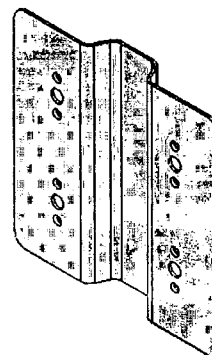
D3637-3F FLAT PATTERN



w/0 62720



D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)



RELEASED
8-22-05

D3637-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	ED	D3637	SHEET 3 OF 3
APPROVED	W	TITLE	SCALE
DE APPR.	W	BRACKET	2:3
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